

WHAT IS CLAIMED IS:

1. An article of footwear, comprising:
an upper and a sole, wherein the sole has an outsole for directly contacting a
ground surface; and
at least one element compression molded with the outsole, wherein the at least one
5 element is formed from a first material comprising at least 45% ethylene vinyl acetate,
approximately 30% polyene elastomer, and approximately 20% synthetic rubber;
wherein a second material of the outsole is compatible for compression
molding with the at least one element and is less hard and less dense than the at least one
element.
2. The article of footwear according to claim 1, wherein the polyene elastomer
is ENGAGE.
3. The article of footwear according to claim 1, wherein the second material
of the outsole includes ethylene vinyl acetate with blowing agents.
4. The article of footwear according to claim 1, wherein the second material
of the outsole is selected from a group consisting of rubber, thermoplastic urethane, and
ethylene vinyl acetate with blowing agents.
5. The article of footwear according to claim 1, wherein the outsole comprises
two materials selected from a group consisting of rubber, thermoplastic urethane, and
ethylene vinyl acetate with blowing agents.
6. The article of footwear according to claim 1, wherein the at least one
element is outwardly visible on the sole.
7. The article of footwear according to claim 1, wherein the at least one
element comprises a plurality of elements and at least one of the plurality of elements is
outwardly visible on the sole.
8. The article of footwear according to claim 1, wherein the at least one
element includes a foil layer that is outwardly visible on the sole.

9. The article of footwear according to claim 1, wherein the at least one element includes an electroplated member that is outwardly visible on the sole.

10. The article of footwear according to claim 1, wherein the at least one element provides torsional reinforcement for the sole.

11. An article of footwear, comprising:

an upper and a sole, wherein the sole has an outsole for directly contacting a ground surface;

at least one element compression molded with the outsole; and

5 at least one cleat receptacle compression molded with the at least one element; wherein a material of the outsole is compatible for compression molding with the at least one element and is less hard and less dense than the at least one element, the at least one element comprises solid ethylene vinyl acetate, and the at least one cleat receptacle is accessible for attachment of a non-metal cleat.

12. The article of footwear according to claim 11, wherein the material of the outsole is selected from a group consisting of rubber, thermoplastic urethane, and ethylene vinyl acetate with blowing agents.

13. The article of footwear according to claim 11, wherein the outsole comprises two materials selected from a group consisting of rubber, thermoplastic urethane, and ethylene vinyl acetate with blowing agents.

14. The article of footwear according to claim 11, wherein the at least one element comprises a plurality of elements and each element of the plurality of elements includes a cleat receptacle.

15. The article of footwear according to claim 11, wherein the at least one element comprises a plurality of elements and at least one element of the plurality of elements includes at least one cleat receptacle.

16. The article of footwear according to claim 11, wherein the at least one element includes a foil layer that is visible on the sole.

17. The article of footwear according to claim 11, wherein the at least one element includes an electroplated member that is visible on the sole.

18. A method of attaching an element to an outsole of a shoe, the method comprising:

providing a block outsole in a preliminary form, the block outsole comprising a first material;

5 providing a sheet of solid ethylene vinyl acetate;
forming the sheet into a desired shape and size to provide a first element; and
compression molding the first element with the block outsole forming a shoe sole;

10 wherein the first material of the block outsole and the solid ethylene vinyl acetate of the first element are compatible for compression molding.

19. The method according to claim 18, wherein the steps of providing a sheet of solid ethylene vinyl acetate and forming the sheet of solid ethylene vinyl acetate comprises:

5 combining approximately 48% EVA 462, approximately 30% polyene elastomer, and approximately 20% synthetic rubber into a machine for kneading;
kneading the mixture for a predetermined amount of time; and
rolling the kneaded mixture until a substantially even thickness is obtained for the sheet.

20. The method according to claim 19, wherein the polyene elastomer is ENGAGE.

21. The method according to claim 18, wherein the first material is selected from a group consisting of ethylene vinyl acetate with blowing agents, rubber, and thermoplastic urethane, and the block outsole is provided in a preliminary form by grinding a larger block of the first material.

22. The method according to claim 18, providing a second material selected from the group consisting of ethylene vinyl acetate with blowing agents, rubber, and

thermoplastic urethane, wherein the second material is different from the first material in elasticity, color, and/or abrasion-resistance, and the second material is compression molded
5 with the block outsole to form a substantially final shoe sole.

23. The method according to claim 18, further comprising:
providing at least one cleat receptacle; and
compression molding the at least one cleat receptacle with the first element
before the step of compression molding the first element with the block outsole.

24. The method according to claim 18, further comprising providing a layer of
foil with the first element before the step of compression molding the first element with the
block outsole.

25. The method according to claim 18, further comprising:
providing at least a second element; and
compression molding the second element with the block outsole;
wherein at least one of the first element and the second element is visible on
5 the shoe sole.